

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 10/25/2006 11:13:58 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Job Number : 29159  
 Estimate Number : 10530  
 P.O. Number : N/A Part Number : D2571  
 This Issue : 10/25/2006 S.O. No. : N/A Drawing Number : D2571 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E  
 Previous Run : 28778 Material : N/A  
 Written By : Due Date : 11/15/2006 Qty: 4 Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: *D25354**K4**En 06/10/30*

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. *B29154* Double check by: *gml*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

*J.G/En**06/11/01*

4

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 &amp; D2572

*J.G/En**06/11/01*

4

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.G/En**06/11/01*

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:13:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 29159

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 06/11/03*

*4*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*q.m*

*06/11/00*

*(4)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING *GREEN*

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M18144*

*yl q.m 06/11/15 x4*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*06/11/16 (4)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *480*

*06/11/16 (4)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/11/16*

Job Completion



*Alodine*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>29159</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	<del>DT8682</del>	0.442	0.442	0.442	0.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.744	1.749	1.749		
E	7.990	8.010		8.001	8.001	8.000	8.002		
F	0.490	0.510		0.497	0.496	0.497	0.497		
G	0.257	0.262	<del>DT8683</del>	0.260	0.260	0.260	0.260		
H	0.375	0.380	<del>DT8684</del>	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.501	0.499	0.499		
J	1.174	1.184		1.176	1.176	1.176	1.177		
K	0.558	0.578		0.562	0.563	0.562	0.562		
L	1.174	1.184		1.176	1.177	1.177	1.177		
M	1.490	1.500		1.494	1.495	1.493	1.495		
N	2.495	2.505		2.500	2.499	2.499	2.498		
O	3.869	3.879		3.872	3.871	3.871	3.876		
P	0.115	0.135		0.128	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.254	0.255	0.255		
S	0.115	0.135		0.125	0.125	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.959	2.960	2.960		
V	0.230	0.250		0.247	0.246	0.245	0.245		
W	0.115	0.135		0.119	0.120	0.119	0.119		
X	0.308	0.313		0.311	0.310	0.310	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.364	0.363	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.628	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.254	0.254	0.255	0.255		
AE	1.375	1.395		1.385	1.384	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.266	0.260		
AH	0.240	0.260		0.259	0.255	0.259	0.259		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.036		
Accept/Reject									






Measured by:	<b>CD/3.6</b>
Date:	<b>06/11/01</b>

Audited by:	<b>mf</b>
Date:	<b>06/11/03</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063" x 45° ALL AROUND                                  |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |

$\triangle E$

Technical drawing of a mechanical part showing a cross-section and a side view.

**Cross-section (Top):**

- Overall width: 8.000
- Central hole diameter:  $\phi 0.005$
- Top surface: R0.66 (TYP)
- Bottom surface: R0.50 (TYP)
- Section line: 2

**Side View (Bottom):**

- Overall length: 8.000
- Central hole diameter:  $\phi 0.005$
- Left and right hole diameters:  $\phi 0.005$
- Left and right hole spacing: 1.750  $\pm 0.005$
- Central hole spacing: 3.500  $\pm 0.005$
- Feature: DART

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEQ 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DRAWN BY		DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
DS	PH		
CHECKED 	APPROVED 	DRAWING NO.	REV. E
		D2571	SHEET 1 OF 1
DATE	TITLE		SCALE
05.07.13	OUTER FWD SADDLE		2:3

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